

304 150

Work Order ID 82268

82268

Page 1

March-27-12 2:46:21 PM

Item ID: D2282-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tube

Stop *NS2*

Start Date: 27/03/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

SL 12/4/5

51 ✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12/4/5

51 ✓

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

OK 12/04/06

51 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82268

82268


Page 2

March-27-12 2:46:21 PM

Item ID: D2282-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube
 Start Date: 27/03/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/10 
 MF
 12-04-09

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NOTE: Date & initial all entries

Picklist Print

March-27-12 2:46:25 PM

Page 1

Work Order ID: 82268

82268

Parent Item: D2282-5

D2282-5

Parent Item Name: Tube

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPRev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	24.3430	0.18006	9.476842			

M304RO 750

304 SS Roundbar .750

**

SA 12/4/15

Location	Loc Qty	Loc Code
MAT028	14.626	
116501	1.746	
116623	12.88	
MAT029	9.717	
117481	1.717	
118509	6.2	
120124	0.3	
120204	1.5	

121282

3 PL

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

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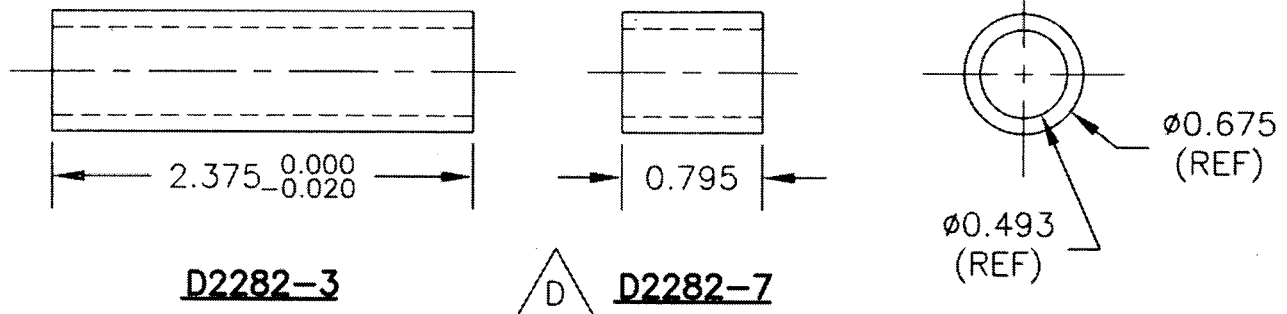
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

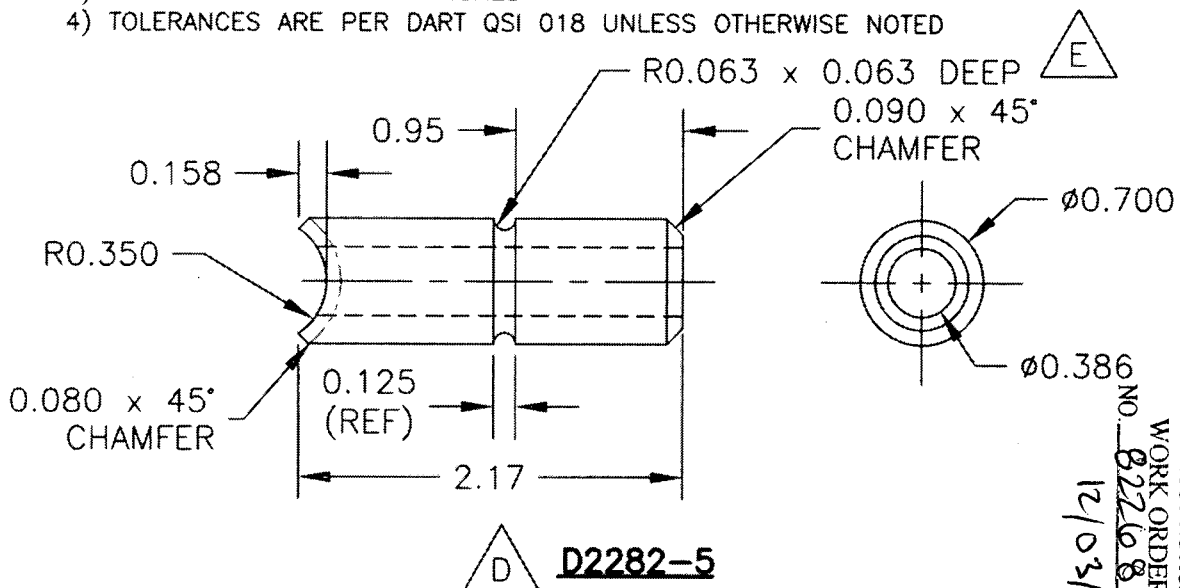
RELEASED
[Signature]

05/09/16



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 82268465
12/03/24

SHOP COPY
RETURN TO
ENGINEERING

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

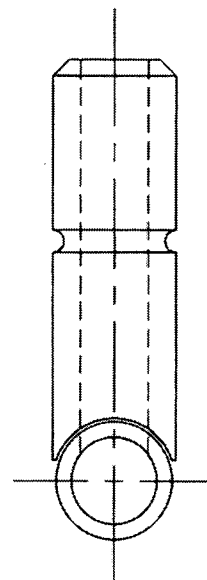
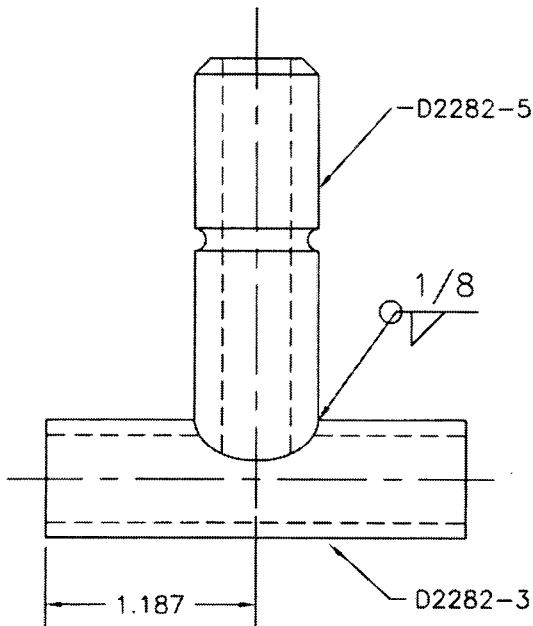
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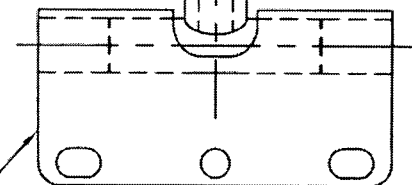
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DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

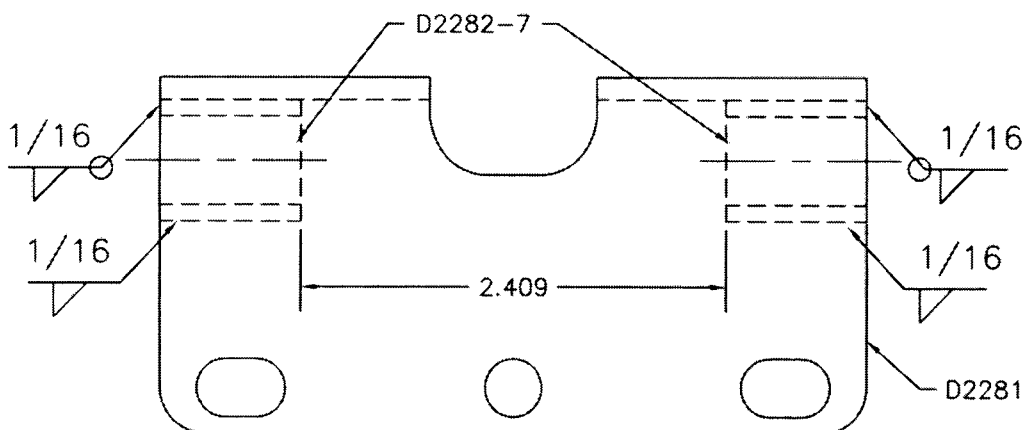


D2282-041
(REF)



D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

2228

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